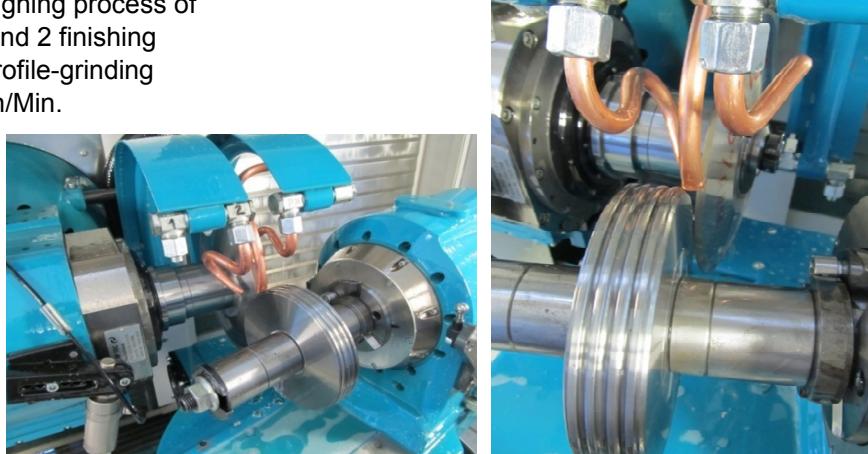


## From-Roll Ø130 L 25

### A20-900

The carbide formroll is preshaped with a roughing process of type plunge-rotate-grinding. A pregrinding and 2 finishing processes were applied of type cylindrical profile-grinding with 2 different wheels at a tool-rpm of 125 n/Min.



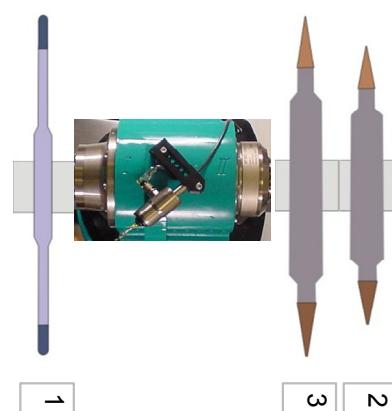
### 1. Cycletime for Production

Workpiece:	Cylindrical blank of Ø130, B=25 mm, Bore 35 mm Material CARBIDE				
Operations	Probe	Prf Rough	Prf Pgrd	Prf fin	Prf fin
Feed [mm/Min]	2000	6	1	1	1
Power [kW]		2	1	1	1
Cutting speed [m/s]		20	22	35	35
Used wheels					
Grinding time [s]	12	1150	4324	4324	2164
Total cycle time	199 Min 34				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	14F1 Ø200 D64 C150 R1
2	14EE1 Ø150 D76V20° R02
3	14EE1 Ø200 D46V20° R01



### 3. Machine and Software Requirements

Machines: 6 axes CNC grinders : SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories:

Responsible engineer: OP, 13.6.14

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